

5/03

DART AEROSPACE LTD	Work Order:	22079
Description: Bracket	Part Number:	D3207-1
		D3207-2
Dwg: D3207 Rev. A page 1	Qty:	30 40
		Page 1 of 1


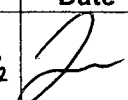
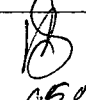
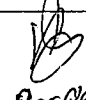
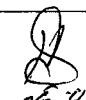
Step	Location	Procedure	By	Date	Qty
1	DC RF 04.06.08	Issue Traveler Note: To be made in multiples of 10 Dwg not required	HA	04.12.08	4
2	MV	(1) Flat pattern makes either D3207-1 or D3207-2 Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3207-1/-2 Batch: M16203	SD EP	04.12.10	40
3	MV	Machine as per Folio FA341 and Dwg D3207 Stack of 10	EP	05.01.20	40
4	QC2	Inspect parts as they come off the CNC machine	SD	05.01.20	40
5	QC8	Second check	ML	05.01.20	40
6	GA	Deburr	Z	05.01.24	40
7	GB	Form 1/2 of stack for D3207-1 as per Dwg D3207 Identify as D3207-1	Z	05.01.24	40
8	GB	Form second 1/2 of stack for D3207-2 as per Dwg D3207 Identify as D3207-2	Z	05.01.24	40
9	QC5	Inspect work to Step 8	MA	05.01.25	4
10	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.01.25	4
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05.01.26	4
12	QC3	Inspect Powder Coat	CL	05.01.27	44
13	ST	Identify and Stock D3207-1 Qty: 4 D3207-2 Qty: 39 40	CL	05.01.27	44
14	AC	Parts to Stock and Prorate cost to parts per Step 13 Cost / part 7.63 7.62	SUC	05.01.28	44
15	DC	Close W/O 7.63 7.62 Inspect Level 21	HA	05.02.02	44

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	

RELEASED

04.05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22079		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-01-24	7	HUMAN error, made All 3207-2 parts (Qty 40) opposite bends turned out to make All -2 in final bending, instead of -1(x20) -2(x20)	 Per Q112	Made D3207-1 to meet Qty required of 4. As per Dwg D3207-1 and A 1:1 Dwg. Scale material Batch# MIS120	 05-01-25	 05-01-25	 Per Q112	 05-01-25

Part No: D3207-1/-2 PAR #: N/A Fault Category: MAN/ MISC NCR: Yes No DQA: Yes Date: 05/01/25
 NOTE: Date & initial all entries QA: N/C Closed: Yes Date: 05-01-25

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022079
Project Name : D3207-2
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3207-2
Description : Bracket
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

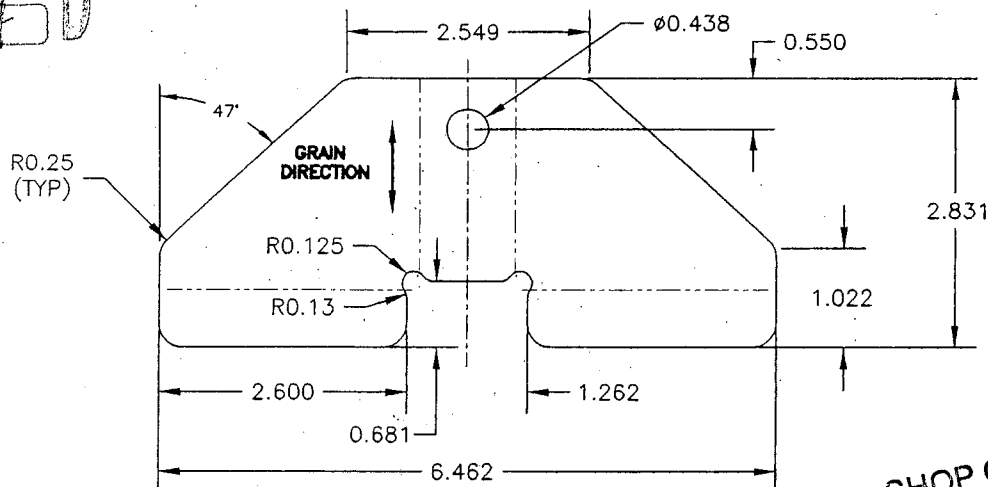
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



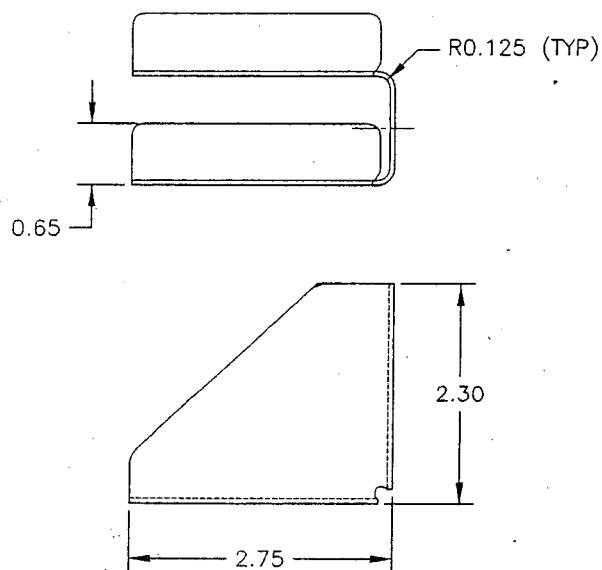
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RELEASED
R 040405 #

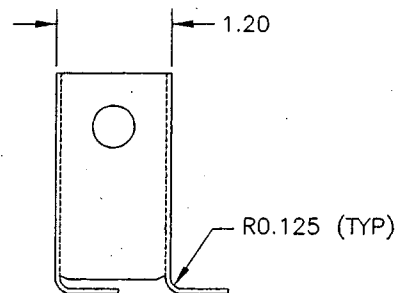
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	



D3207-1/-2 FLAT PATTERN



**D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE**



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22079

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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